

Part No: D3914-041
 Job Qty: 1 ea
 Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs
 Status: Scheduled
 Priority: Medium
 Job Tracking No:
 Created By: Mario Poulin
 Description:
 Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV,pct DD VERF:JLM IPP REV:D 13.06.21 DWG REV,C DD VERF:JFS
 Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run	Workcenter/Supplier	
						hrs	Lead Time
90	Start up Operation	1 Ea	12/19/17	0.00 0.00	0.00 0.00	Start Up Large Fab2	Sign-off
100	Large Fab	1 pcs	12/19/17	0.00 6.67	0.00 0.00	Large Fab 1	
110	QC	1 pcs	12/19/17	0.00 0.00	0.00 0.00	QC9	18-01-11
120	QC	1 pcs	12/19/17	0.00 0.00	0.00 0.00	QC5	18-01-15
130	Powdercoat	1 pcs	12/19/17	0.00 0.40	0.00 0.40	Powdercoat4	18-01-15
135	QC	1 pcs	12/19/17	0.00 0.00	0.00 0.00	QC3	18-01-15
140	HandFinish	1 pcs	12/20/17	0.00 0.80	0.00 0.80	HandFinish3	18-01-15
150	QC	1 pcs	12/20/17	0.00 0.00	0.00 0.00	QC3	18-01-15
160	Packaging	1 pcs	12/20/17	0.00 0.00	0.00 0.00	Packaging3	18-01-15
170	QC21-SA	1 Ea	12/20/17	0.00 0.00	0.00 0.00	QC21	18-01-15

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***
 130 - - *** mask sides of hinge prior to powdercoat***
 140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	103	0	0
	D3914-1	2	16	0	0
	D3914-7	2	12	0	0
	D4016-3	3	5	0	0
	D4018-5	9	63	0	0
	D4020-5	1	5	0	0
	D4021-3	1	14	0	0
	D4035-043	2	10	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.



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Long Basket Lid Assembly (350)

PART NO: D3914-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 01/08/18

Job No: 168149